

Date: Tuesday, 17/02/2009 10:19:16 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 45834		
Estimate Number	: 13596		
P.O. Number	:	Part Number	: D38152
This Issue	: 17/02/2009 S.O. No. :	Drawing Number	: D3815 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	:	Material	:
Written By	:	Due Date	: 24/02/2009 Qty: 20 Um: Each
Checked & Approved By	: <u>09.02.17</u>		
Comment	: Est Rev:A 08-09-18 new issue DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4859 sf(s)/Unit Total : 9.7188 sf(s)  
 2024-T3 .063 sheet  
 batch: 110337 RB 9-2-07

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3815  
 Dwg Rev: A RB 9-2-07  
 Prog Rev: 1  
 \*\*\*\*grain direction along 4.30" \*\*\*\*  
 2-Deburr if necessary RB 9-2-07

27 Pto →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/02/27 counters 426

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 1- deburr if necessary  
 2- Bend as per Dwg D3815

ACCEPTABLE TO USE RO.19  
 THIS W/O CWLY.

09.03.03



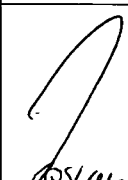
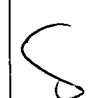




20 09/03/03

26

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3815-2 PAR #: N/A Fault Category: Pool / ~~For Assy~~ male Small NCR: Yes No DQA: A Date: 09/03/04  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: A Date: 09/03/04

NCR: <u>45834</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/2/27	# 20	one (Qty 1) part found with large mark in upper left corner		Scrap and destroy no need to replace <del>it</del> extra's were made QH (x1)	BB 9-2-27			
		R.C. material marking from <del>sample</del> w. Jet. malfunction / blow-out						

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:19:16 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 45834

Part Number: D38152

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



-25

center

Comment: INSPECT WORK TO CURRENT STEP

09/03/03

X26

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



X26

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.d./H

09/03/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



jh

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-03

X26

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: G-A 09/03/03

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/04

Job Completion



MF  
09-03-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 45834
<b>Description:</b> ANGLE		<b>Part Number:</b> D 3815-2
<b>Inspection Dwg:</b> D3815-2, Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

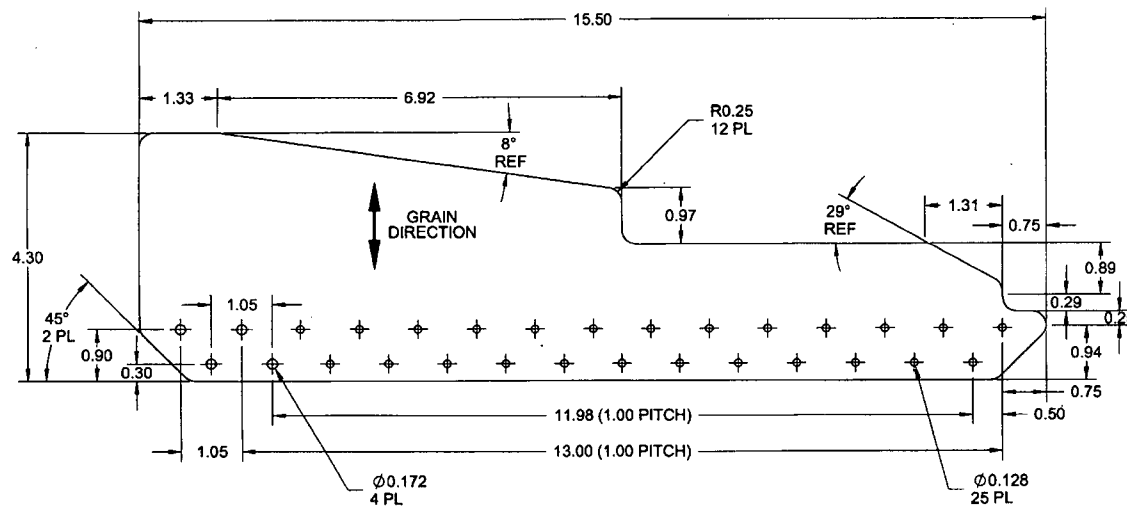
☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .178	+.005 - .001	.171	✓			
Ø .172	+.005 - .001	.175	✗			
.30	.030	.309	✗			
.90	.030	.908	✗			
1.05	.030	1.054	✗			
1.05	.030	1.054	✗			
4.30	.030	4.300	✗			
1.33	.030	1.335	✓			
11.98	.030	11.998	✓			
1.00	.030	1.000	✓			
13.00	.030	13.015	✗			
1.00	.030	1.030	✗			
.50	.030	.502	✗			
.75	.030	.747	✗			
.94	.030	.941	✗			
.25	.030	.244	✗			
.29	.030	.293	✗			
.89	.030	.888	✗			
.75	.030	.762	✗			
15.50	.030	15.58	✗			
.061	.010	.062	✗			

<b>Measured by:</b> PB	<b>Audited by:</b> S	<b>Prototype Approval:</b> 1
<b>Date:</b> 9-2-27	<b>Date:</b> 09/02/27	<b>Date:</b> 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

*[Handwritten signature]*



**D3815-1F FLAT PATTERN**

1.890  
 .290  
 1.180  
 .250  
 1.430  
 .940  
 2.370

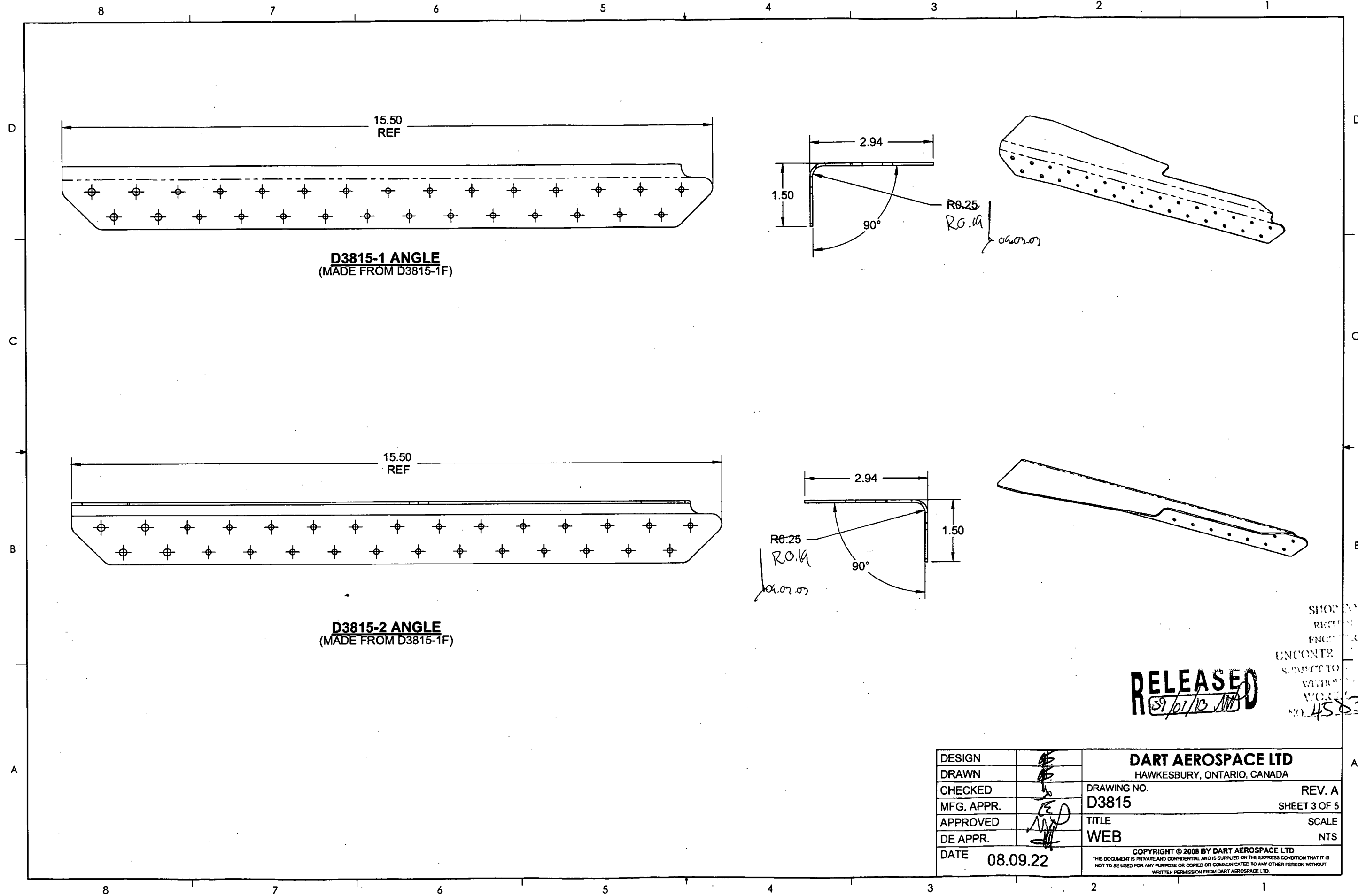
45834

**RELEASED**  
 07/01/13

**NOTES:**

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 2 OF 5
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**D3815-1 ANGLE**  
(MADE FROM D3815-1F)

**D3815-2 ANGLE**  
(MADE FROM D3815-1F)

**RELEASED**  
59/01/13

SHOP COPY  
RETURNED  
ENCLOSURE  
UNCONTROLLED COPY  
SUBJECT TO  
VENDOR'S  
WORK  
NO. 45834

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3815	SHEET 3 OF 5
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